

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
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LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 145925

Friday, May 06, 2016 10:45:07 AM

145925

Page 2

Item ID: D3262-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 4/26/2016 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 5/5/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.12		B.A 16/07/25		6	0		DAS 08 9-89
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo LOCATION : WA003	0.00 0.06				6	DAS 6 9-89		JUL 25 2016
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.60					DAS 21 9-89	JUL 26 2016	

DAS
21
9-89

JUL 26 2016

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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

Friday, May 06, 2016 10:45:05 AM

Page 1

Work Order ID: 145925

145925

Parent Item: D3262-3

D3262-3

Parent Item Name: Cap

Start Date: 4/26/2016

Required Date: 5/5/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.03.10Removed P/O for liquid penetrant
inspectionKJ/JLM
Rev:D as per ECN10-571 DD 10.05.10 verified :EC

IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6B0.500X06.00
0

Purchased

No

100

f

20.2510

0.45

2.842105

DAS
20
9-89

M6061T6B0 500X06 000

6061-T6 Bar .500 x 6.00

**

3.168'

16-07-22

Location

Loc Qty

Loc Code

MAT001

20.251

cl12567

0.83

122521

12

cl128437

0.921

cl129375

6.5

0.830'

0.921'

1.417'

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OTHER : _____					

DART AEROSPACE LTD		Work Order: 145925
Description: Cap		Part Number: D3262-3
Inspection Dwg: D3262	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.070 x 45°	+/-0.010	.080 x 45°	/		vern	
0.13	+/-0.030	.130	/		↓	
R0.063	+/-0.010	.063	/			
0.080	+/-0.010	.079	/			
0.25	+/-0.030	.247	/			
Ø5.005	+0.010/-0.000	5.006	/			
Ø0.875	+/-0.010	.873	/		↓	
3.25	+/-0.005	3.250	/			
Ø0.516	+0.005/-0.000	.517	/			
Ø5.165	+/-0.010	5.164	/		gage Pin vern	
0.696	+0.007/-0.008	.690	/		gage Pin ↓	
0.588	+0.005/-0.000	.589	/			
0.091	+0.007/-0.008	.092	/		vern	
0.45	+/-0.030	.449	/		↓	

Measured by: P-16-07-23	Audited by: R.E. DAS	Preliminary Approval:
Date:	Date: 16/07/25	Date:

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	05.04.28	Dimensions and tolerances revised	KJ/JLM	
C	06.09.27	Dimensions revised per rev. C	KJ/JLM	
D	07.09.06	0.080 was 0.090	KJ/JLM	
E	10.08.03	Dimensions update per Dwg Rev E	KJ	
F	14.08.26	Dwg Rev updated to Rev F	KJ	

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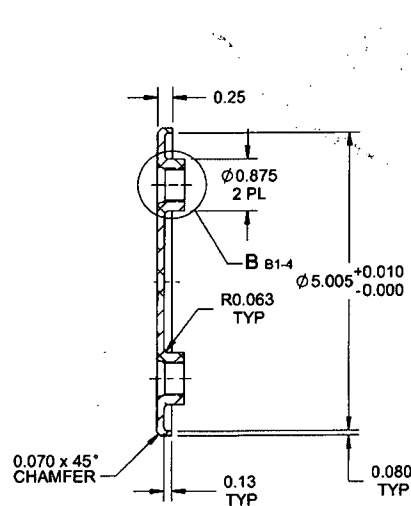


WORK ORDER NON-CONFORMANCE / UPDATE

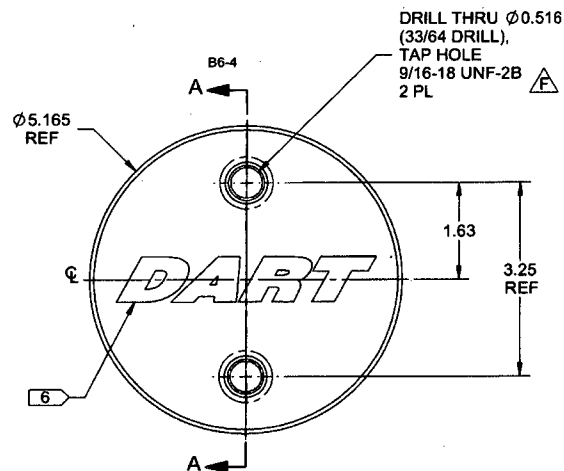
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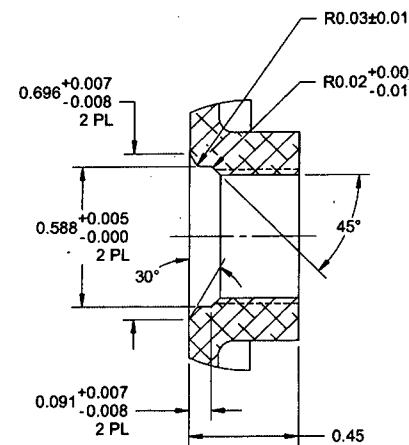
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



SECTION A-A C5-4



D3262-3 CAP



DETAIL B C7-4
SCALE 2X

NOTES:

- 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
- 7) WEIGHT: 0.28 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

145925

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. F
MFG. APPR.	JLM	D3262	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	FUEL PURGE CANISTER	NTS
DATE	14.06.26	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASE
2014-07-15

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